

19

DART AEROSPACE LTD	Work Order:	18956
Description: Bearpaw Kit (19" x 16")	Part Number:	K10007
Dwg: D2435 Rev. E1	Qty:	10 Kit
		Page 1 of 1

FF 03.05.26

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10007 Kit consists of Qty (2) D2435 Dwg not required	HJ	03.03.18	10
2	DC	Photocopy bluefile: K10007 D206-559 D500-572 D120-638 D058-678 and create labels per PPP K10007 CHG003 uk mha (Bag Bluefiles separately) For K5	Sur	03.04.01	10
3	GA	Cut 2 blanks per K10007 Kit Cut blank: 16.00" x 20.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) Batch: M13307	9MK	03/05/26	10
4	MV	Inspect material for defects or damage prior to machining	SL	03/05/29	10
5	MV	Machine as per Folio D2435 and Dwg D2435	SL	03/05/29	10
6	QC2	Inspect parts as they come of the CNC machine	SL	03/05/29	10
7	MV	Deburr	SL	03/05/29	10
8	QC8 & 5	Second inspection	EC	03/05/29	10
9	KP	Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3) Qty Part Number Description Batch 4 D2182B050 Rubber Cushion B18914 8 D2274 Radius Block B18743 2 D2435 Bearpaw B18950 4 D2438 Clamp B18579 8 D2529 Washer B18539 8 AN4-15A Bolt M12207 8 AN4-17A Bolt M11045 16 AN960JD416 Washer M12749 8 MS21042L4 Nut (or -4) M11151 2 QS200M44S Clamp M13103/M13043 1 Paperwork package from Step 2	Q	03-04-10 03-04-10 03-05-30	10 10 10
10	QC4	Inspect Kit for 100% Completeness on the W/O	h	03.06.02	10
11	PK	Identify and pack for shipping as per PPP K10007 REV. D	Q	03.06.03	10
12	AC	Cost / part 107.50	Sur	03.06.04	10
13	DC	Close W/O 133.96 Inspect Level 21	AB	03.06.04	

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10007 created for Bear paw kit (MPP 2000)	EC	
B	01.03.21	Added OH-58 paperwork (MPP 2092)	EC	
C	01.11.08	Revised Step 3 and Added Level 21	SM	
D	03.03.26	Reformat; Incorporated D2435	KJ/RF	

Work Order:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

19

DART AEROSPACE LTD	Work Order:	18956
Description: Bearpaw Kit 19" x 16"	Part Number:	K10007
Drawing: K10007 rev. B	Qty:	10

Step	Location	Procedure	By	Date	qty																																												
1	EXPEDITING	Issue Work Order	KJ	03.03.18	10																																												
2	EXPEDITING	Photocopy blue file: K10007 D559-011, D572-011, D638-011 D678-011 type labels per PPP K10007 (Bag Blue files separately)	RF 03.01.08 GHC-002 CHG 003 WK 17 KJ																																														
3	STORES	Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2182B050</td><td>Rubber cushion</td><td>B18914</td></tr><tr><td>8</td><td>D2274</td><td>Radius block</td><td>B18743</td></tr><tr><td>2</td><td>D2435</td><td>Bearpaw</td><td>B18956</td></tr><tr><td>4</td><td>D2438</td><td>Clamp</td><td>B18579</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B18539</td></tr><tr><td>8</td><td>AN4-15A</td><td>Bolt</td><td>M12207</td></tr><tr><td>8</td><td>AN4-17A</td><td>Bolt</td><td>M11045</td></tr><tr><td>16</td><td>AN960JD416</td><td>Washer</td><td>M12749</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M11151</td></tr><tr><td>2</td><td>QS200M44S</td><td>Clamp</td><td></td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2182B050	Rubber cushion	B18914	8	D2274	Radius block	B18743	2	D2435	Bearpaw	B18956	4	D2438	Clamp	B18579	8	D2529	Washer	B18539	8	AN4-15A	Bolt	M12207	8	AN4-17A	Bolt	M11045	16	AN960JD416	Washer	M12749	8	MS21042L4	Nut (or -4)	M11151	2	QS200M44S	Clamp			03-04-10	10
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2	QS200M44S	Clamp																																															
4	QC	Inspect Level 4																																															
5	STORES	Package and Identify as per PPP K10007																																															
6	EXPEDITING	Close Work Order Inspection Level 21 Cost / part:																																															

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10007 created for Bear paw kit (MPP 2000)	EC	
B	01.03.21	Added OH-58 paperwork (MPP 2092)	EC	
C	01.11.08	Revised Step 3 and Added Level 21	SM	EC

RELEASED

EC 01.11.09

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector	

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: _____ Date: _____



DESIGN <i>KE</i>		DRAWN BY <i>KE</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ND</i>		APPROVED <i>ND</i>		DRAWING NO. D2435	
DATE 98.05.19		TITLE BEARPAW		REV. E SHEET 1 OF 2	
A	96.01.24	NEW ISSUE			
B	96.03.26	CHANGE BORE AND C'BORE DEPTH			
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED			
SHOP COPY 97.10.17		R1.5 BORE WAS R2.637 (TSR A469)			
RETURN TO ENGINEERING 98.05.19		CHANGE C'BORE, R1.58 WAS R1.50			

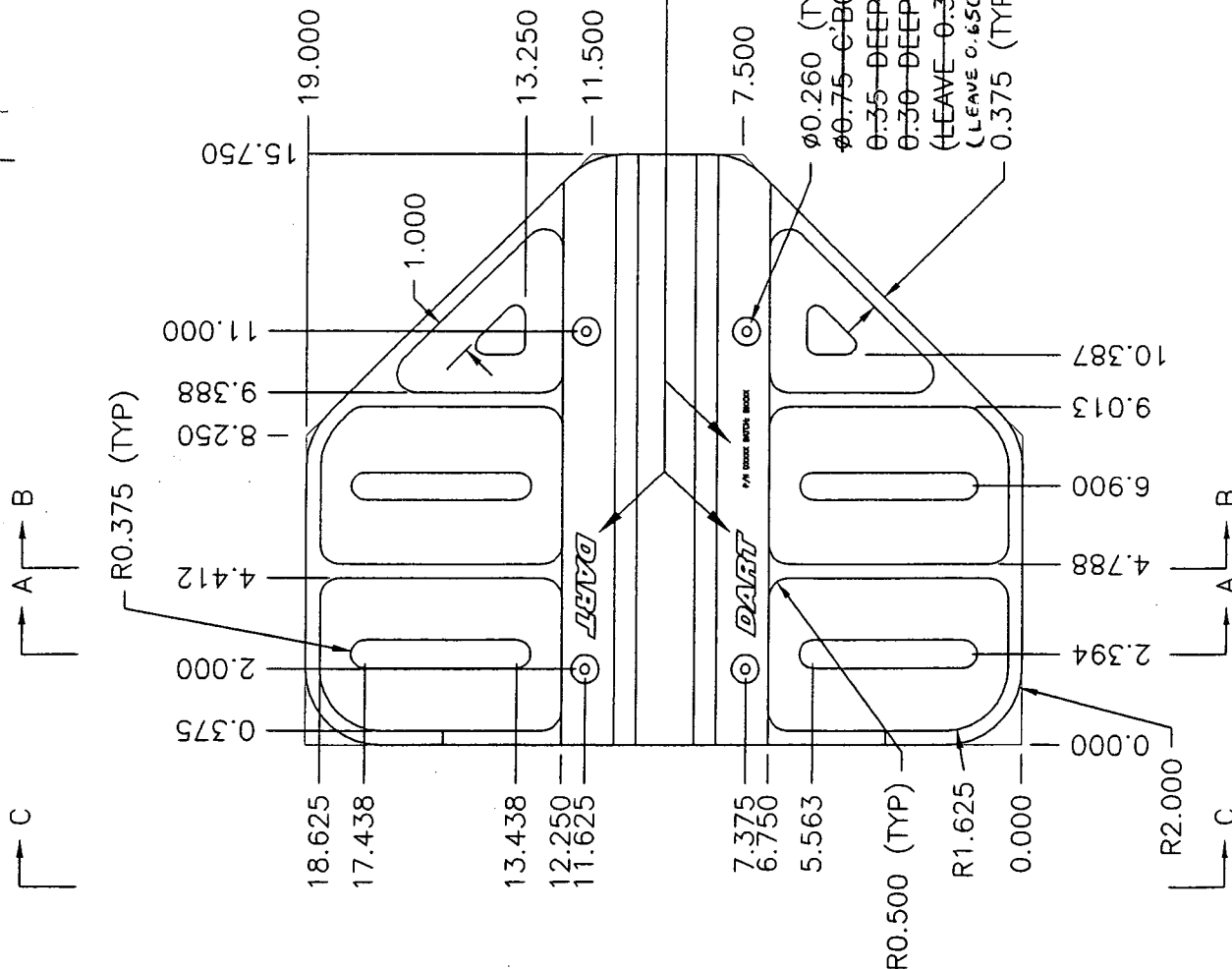
EFFECTIVE DEOS

9143	

**UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE**

WORK ORDER
NO. 18956

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ME</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

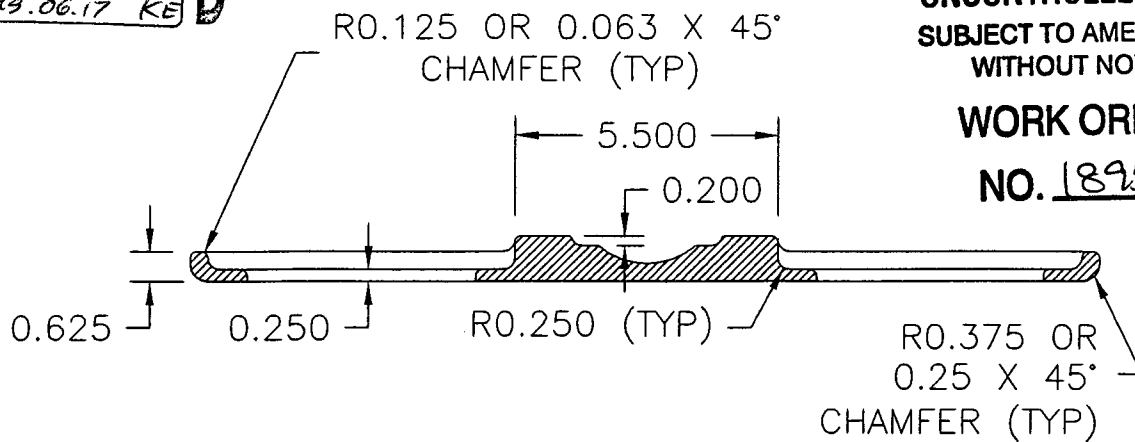
SHOP COPY

RETURN TO
ENGINEERING

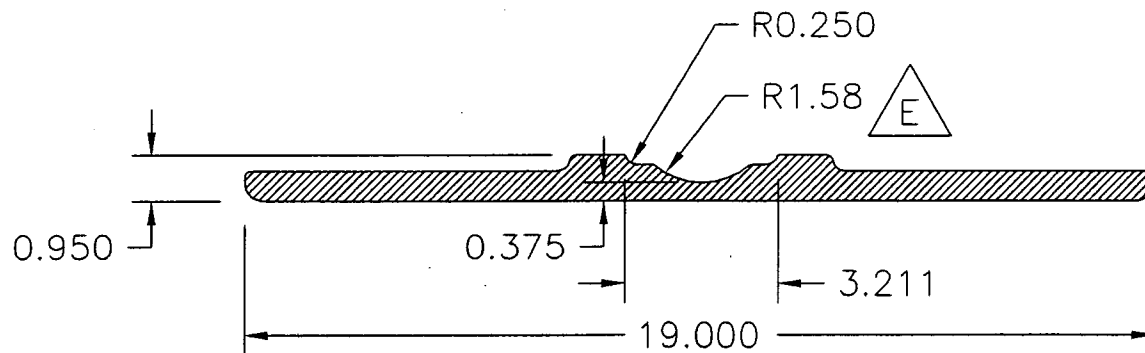
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WITHOUT NOTICE

WORK ORDER

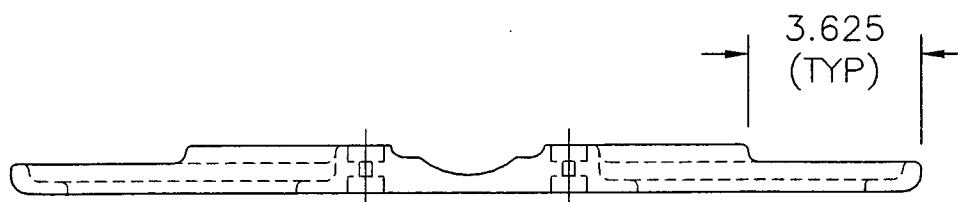
NO. 18956



SECTION A-A



SECTION B-B



SECTION C-C

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. K10007	REV. B SHEET 1 OF 1
DATE 00.08.29		TITLE BEARPAW KIT 19" WIDE x 16" LONG SCALE NTS	
A	99.12.06	NEW ISSUE	
B	00.08.29	ADD D058-678-011	

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING BEARPAW INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206A/B	D206-559-011
MD 500	D500-572-011
EC 120	D120-638-011
OH-58 A/A+/C	D058-678-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10007	D206-559-011	D500-572-011	D120-638-011	D058-678-011
D2182B050	4	4	4	4	4
D2274	8	8	8	8	8
D2435	2	2	2	2	2
D2438	4	4	4	4	4
D2529	8	8	8	8	8
AN4-15A	8	8	8	8	8
AN4-17A	8	8			8
AN960JD416	16	16	8	16	8
MS21042L4(OR -4)	8	8	8	8	8
QS200M44S	2	2	2		2

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 18956

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 18, 2003
10:34 am

Work Order No : 0018956
Project Name : *K10007
Project For : week 319
Work Order Type : Main
Main WO Number :
House Part Number : *K10007
Description : Bearpaw Kit 19" x 16"
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date :
Est Finish Date : 05-09-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



Dart Aerospace, Ltd

1270 Aberdeen Street

Hawksbury, Ontario

K6A 1K7

Tel: (613) 632-3336 Fax: (613) 632-4443

Supplier Code: _____ Sheet ____ of ____

INSPECTION CHECKLIST

PART NO.: D2435

PHY. CHANGE: _____

DESCRIPTION: Beam

DRAWING CHANGE: REV E

MANUFACTURING DATE: 03/05/27

UNICORP E.O.'S: _____

BATCH NO.: 18956

SERIAL NO.: _____

PURCHASE ORDER NO.: _____

QUANTITY ACPT. _____ REJ. _____

DATA SHEET NO.: _____

☒ FIRST ARTICLE

☐ PERIODIC CONFORMITY

☐ FINAL INSPECTION

ITEM	DWG PAGE	DRAWING DIMENSION	TOL.	ACTUAL DIMENSION	ACC.	REJ.	% OF INSP.	Method of Inspection	Comments
1	1	0.260	±0.005	0.263	✓			VER	
1	1	0.300	±0.005	0.293	✓			VER	
1	1	0.400	±0.005	0.397	✓			VER	
1	1	0.400	±0.005	0.403	✓			VER	
1	1	4.250	±0.005	4.251	✓			"	
1	1	0.063	±0.005	0.060	✓			"	
1	1	0.05	±0.005	0.051	✓			"	
1	1	0.950	±0.005	0.950	✓			MIC	
1	1	0.250	±0.005	0.250	✓			VER	
1	1	0.625	±0.005	0.623	✓			"	
1	1	0.500	±0.005	0.495	✓			O-MIC	
1	1	0.375	±0.005	0.375	✓			VER	
1	1	19.000	±0.005	19.000	✓			M-FACE	
1	1	15.750	±0.005	15.750	✓			"	
1	1	5.500	±0.005	5.500	✓			VER	
1	1	1.000	±0.005	1.000	✓			"	
1	1	0.375	±0.005	0.382	✓			"	
1	1	2.000	±0.005	1.997	✓			"	

H:\admin-qaliso\forms\first article inspectionA

Rev. B

Mesured by: SP

Audited by: KE

Approved by: _____